

94898

Page 1

N900040100

Setup Start *NS1*

Stop. *NS2*

Cust Item ID:

4

4

Customer:

Reference:

Run Start *NR1*

Date: 13-01-0 Tooling:

Date:

Stop ***NR2***

QC:

Date: _____ **SPC (Y/N):** _____

Date:

Draw Nbr	Revision Nbr
D2918	Rev B

00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program batch numberMachine Step No 1 as per Folio FA440 and visually inspect as per Dwg D2918 & attached Dimension SheetMachine Step No 2 as per Folio FA440 and visually inspect as per Dwg D2918 & attached Dimension SheetMachine Step No 3 as per Folio

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per Dwg D2918 & attached dimension sheet

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Work Order ID 94898

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Item ID: D2918-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle RH
 Start Date: 12/21/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/28/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				4	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	26	13-1-11	
150 *150* Powdercoat Powder Coating	White Gloss(Ref 4.3-5.1) per QSI005 4.3-Alum M 123383 Memo START TIME: <u>10:00</u> OVEN TEMPERATURE: <u>325</u> FINISH TIME: <u>10:30</u>	0.00 0.00				4	0	13-1-14	

Work Order ID 94898

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Item ID: D2918-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle RH

Start Date: 12/21/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/28/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

H 4 13/01/14

170

Identify as per dwg & Stock Location **ST 426** 0.00

170

Packaging

Memo

0.00

Packaging

4x 13-01-14

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/1/14 ME 13-1-14

Picklist Print

Friday, December 21, 2012 4:10:38 PM

Page 1

Work Order ID: 94898

Parent Item: D2918-2

Parent Item Name: Saddle RH

Start Date: 12/21/2012

Required Date: 12/28/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A04.07.16New IssueKJ/JLM
IPP B 07.08.07 ECN930 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-011 Saddle Billet		Manufactured	No			100	Each	16.0000	1	4			

Location

MAT047

75834

Loc Qty

16

16

Loc Code

4

BC 13.01.09

DART AEROSPACE LTD		Work Order: 94898
Description: Saddle RH		Part Number: D2918-2
Inspection Dwg: D2918	Rev. B	Page 1 of 1

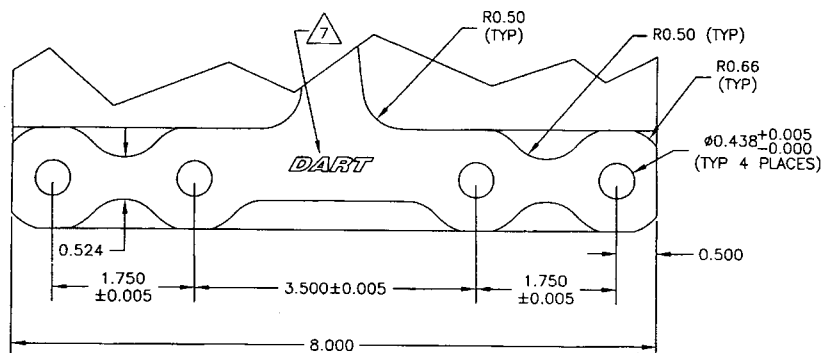
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.090	0.110		-100	-100	-100	-100		
B	0.175	0.205		-192	-194	-193	-193		
C	0.175	0.217		-210	-206	-208	-208		
D	R0.470	0.530		-500	-500	-500	-500		
E	0.740	0.760		-760	-760	-760	-760		
F	0.277	0.297		-293	-286	-287	-287		
G	3.170	3.230		3.200	3.200	3.200	3.200		
H	0.180	0.220		-180	-180	-180	-180		
I	1.599	1.619		1.615	1.613	1.613	1.613		
J	0.250	0.270		-264	-262	-262	-262		
K	4.436	4.446		4.441	4.441	4.441	4.441		
L	1.498	1.508		1.503	1.503	1.503	1.503		
M	1.278	1.288		1.283	1.283	1.283	1.283		
N	0.053	0.073		-060	-060	-060	-060		
O	1.103	1.113		1.108	1.108	1.108	1.108		
P	1.225	1.235		1.230	1.230	1.230	1.230		
Q	0.257	0.262		-258	-258	-258	-258		
R	2.000	2.020		2.001	2.006	2.004	2.004		
S	1.385	1.400		1.386	1.391	1.389	1.389		
T	0.760	0.765		-760	-760	-760	-760		
U	0.307	0.312		-310	-310	-310	-310		
V	0.615	0.635		-625	-625	-625	-625		
W	0.438	0.443		-438	-438	-438	-438		
X	0.490	0.510		-500	-500	-500	-500		
Y	1.745	1.755		1.750	1.750	1.750	1.750		
Z	3.495	3.505		3.500	3.500	3.500	3.500		
AA	7.990	8.010		8.000	8.000	8.000	8.000		
AB	0.023	0.043		-033	-033	-033	-033		
AC	0.178	0.198		-188	-188	-188	-188		
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	13-01-10

Audited by:	[Signature]
Date:	13/01/10

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	
C	08.11.27	Added dimension 'AB,AC', Revised Dimension 'R'	KJ/JLM	[Signature]

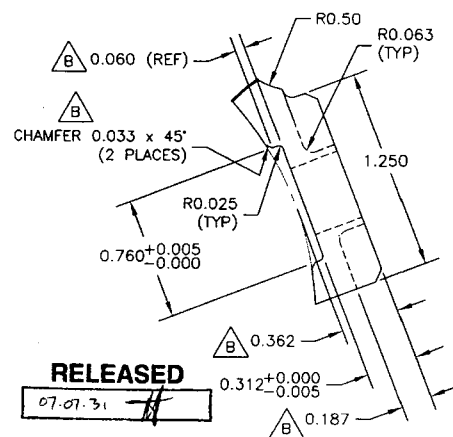


VIEW B-B

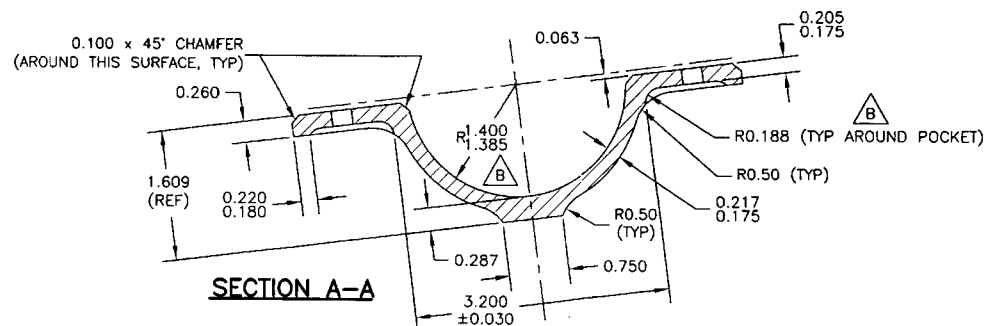
D2918-1 LH SADDLE (SHOWN)
D2918-2 RH SADDLE (OPPOSITE)

NOTES:

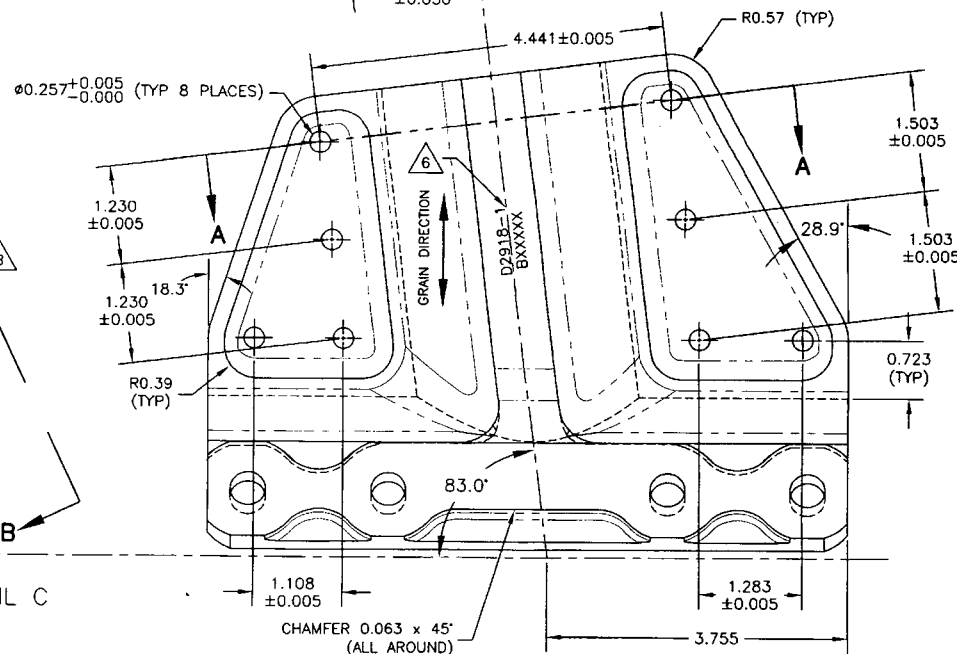
- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



DETAIL C
 SCALE 4:3



SECTION A-A



B	07.02.19	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	GP	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.02.19	TITLE
		SADDLE

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DART DART AEROSPACE LTD.
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2918

REV. B

SHEET 1 OF 1

SCALE

2:3